
Oprema in pribor za utekočinjeni naftni plin (UNP) - Postopek za preverjanje jeklenk za UNP pred polnjenjem, med njim in po njem

LPG equipment and accessories - Procedure for checking transportable refillable LPG cylinders before, during and after filling

Flüssiggas-Geräte und Ausrüstungsteile - Kontrollverfahren für Flaschen für Flüssiggas (LPG) vor, während und nach dem Füllen

Équipements pour GPL et leurs accessoires - Procédure de vérification des bouteilles transportables et rechargeables pour GPL avant, pendant et après le remplissage

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**LPG equipment and accessories - Procedure for checking
transportable refillable LPG cylinders before, during and after
filling**

Flüssiggas-Geräte und Ausrüstungsteile - Kontrollverfahren
für Flaschen für Flüssiggas (LPG) vor, während und nach
dem Füllen

This draft European Standard is submitted to CEN members for enquiry. It has been drawn up by the Technical Committee CEN/TC 286.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

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Foreword

This document (prEN 1439:2015) has been prepared by Technical Committee CEN/TC 286 “Liquefied petroleum gas equipment and accessories”, the secretariat of which is held by NSAI.

This document is currently submitted to the Enquiry.

This document will supersede EN 1439:2008.

This document has been prepared under a mandate given to CEN by the European Commission and the European Free Trade Association.

This European Standard has been submitted for reference into the RID and/or in the technical annexes of the ADR.

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Introduction

This draft European Standard calls for the use of substances and procedures that can be injurious to health if adequate precautions are not taken. It refers only to technical suitability and does not absolve the user from legal obligations relating to health and safety at any stage.

It has been assumed in the drafting of this draft European Standard that the execution of its provisions is entrusted to appropriately qualified and experienced people. Where judgements are called for, it has been assumed that they are made by competent persons who have been trained specifically for the tasks.

Protection of the environment is a key political issue in Europe and elsewhere, for CEN/TC 286 this is covered in CEN/TS 16765 [3]; this Technical Specification should be read in conjunction with this draft standard.

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1 Scope

This draft European Standard specifies the procedures to be adopted when checking transportable refillable LPG cylinders before, during and after filling.

This draft European Standard applies to transportable refillable LPG cylinders of water capacity not exceeding 150 l.

This draft European Standard does not cover the requirements for filling LPG cylinders that are designed and equipped for filling by the user.

This draft European Standard does not cover the requirements for filling LPG containers on vehicles.

This draft European Standard is applicable to the following:

- welded and brazed steel LPG cylinders with a specified minimum wall thickness (see EN 1442 and EN 12807 [1] or an equivalent standard);
- welded steel LPG cylinders without specified minimum wall thickness (see EN 14140 or an equivalent standard);
- welded aluminium LPG cylinders (see EN 13110 [2] or an equivalent standard);
- composite LPG cylinders (see EN 14427 or an equivalent standard); and
- over-moulded cylinders (OMC).

Specific requirements for different types of cylinders are detailed in Annex A, Annex B, Annex C, Annex D and Annex G.

This draft standard is intended to be applied to cylinders complying with RID/ADR [4][5] (including pi marked cylinders) and also to existing non RID/ADR cylinder populations.

2 Normative references

The following documents, in whole or in part, are normatively referenced in this document and are indispensable for its application. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

EN 549, *Rubber materials for seals and diaphragms for gas appliances and gas equipment*

EN 1440, *LPG equipment and accessories — Periodic inspection of transportable refillable LPG cylinders*

EN 1442, *LPG equipment and accessories — Transportable refillable welded steel cylinders for LPG — Design and construction*

EN 10028-7, *Flat products made of steels for pressure purposes — Part 7: Stainless steels*

EN 12816, *LPG equipment and accessories — Transportable refillable LPG cylinders — Disposal*

EN 13952, *LPG cylinders — Filling procedures*

EN 14140, *LPG equipment and accessories — Transportable refillable welded steel cylinders for LPG — Alternative design and construction*

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EN 14427, *LPG equipment and accessories — Transportable refillable fully wrapped composite cylinders for LPG — Design and construction*

EN 14894, *LPG equipment and accessories — Cylinder and drum marking*

prEN 16728, *LPG equipment and accessories — Transportable refillable traditional LPG cylinders other than traditional welded and brazed steel cylinders — Periodic inspection*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.1**liquefied petroleum gas****LPG**

low pressure liquefied gas composed of one or more light hydrocarbons which are assigned to UN 1011, UN 1075, UN 1965, UN 1969 or UN 1978 only and which consists mainly of propane, propene, butane, butane isomers, butene with traces of other hydrocarbon gases

3.2**competent person**

person which by combination of appropriate qualification, training, experience, and resources, is able to make objective judgments on the subject

3.3**competent authority**

authority or authorities or any other body or bodies designated as such in each State and in each specific case in accordance with domestic law

3.4**over-moulded cylinder****OMC**

coated steel or stainless steel cylinder with a non-removable over-moulded protective case in polyurethane or material which provides equivalent protection

Note 1 to entry: See also ADR definition.

3.5**casing**

permanently attached sleeve covering part of, or the whole of the pressure envelope of a composite cylinder, usually incorporating a foot ring and a shroud

Note 1 to entry: Permanently attached means that casing cannot be removed during service without destruction, or by using special tools.

3.6**filling ratio**

ratio of the mass of gas introduced into a cylinder or pressure drum to the mass of water at 15 °C that would fill the same cylinder or pressure drum fitted ready for use

3.7**reference temperature**

temperature used for the calculation of the safe filling quantity

3.8**filled to a level**

filled to a fixed level using a fixed liquid level device

3.9**filled by volume**

filled with a fixed volume of LPG

3.10**filled by mass**

filled with LPG using a weighing machine

3.11**filling plant**

facility where filling and checking of LPG cylinders takes place

3.12**reconditioning**

major repairs to cylinders, which can include hot work, welding or de-denting carried out by specialists away from potential sources of flammable air/gas mixture

3.13**periodic inspection**

activities carried out at defined intervals, such as examining, measuring, testing or gauging the characteristics of a pressure vessel and comparing these with specified requirements

3.14**tare mass**

sum of the mass of the empty cylinder, the mass of the valve including a dip tube where fitted, and the mass of all other parts that are permanently attached to the cylinder when it is being filled, e.g. fixed valve guard

4 Segregation of cylinders prior to filling**4.1 General**

Cylinders shall be checked and segregated into the categories specified in 4.2 to 4.4 by a competent person.

NOTE A flow diagram of the checks before, during and after filling is given in Annex F.

4.2 Cylinders suitable for filling

The cylinder shall be deemed suitable for filling if the following conditions apply:

- a) tare indication and water capacity are marked;
- b) allowed quantity and identification of the product (butane, propane or mixtures thereof, the properties of which were considered for the design of the cylinder) are indicated;
- c) cylinder is within the test date as determined from the marked manufacture date or periodic inspection date;
- d) cylinder does not have unacceptable physical damage, corrosion or other defects. For metallic cylinders, the inspection of the foot-ring for corrosion or damage shall determine the need for a more thorough external visual examination of the cylinder base; and
- e) cylinder is fitted with a pressure relief valve, if required by the manufacturing standard.

4.3 Cylinders for periodic inspection

A cylinder shall be set aside for periodic inspection in accordance with EN 1440 or prEN 16728 when either of the following conditions apply:

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- a) cylinder is out of test date; or
- b) cylinder cannot be confirmed to be within test date.

4.4 Cylinders requiring further assessment

A cylinder shall be set aside for further assessment (see Clause 5), if:

- a) the tare indication of a cylinder, filled by mass, is missing or illegible;
- b) the water capacity of a cylinder, filled by volume, is missing or illegible;
- c) the cylinder is judged to have unacceptable physical damage, corrosion or other defects;
- d) the valve or pressure relief valve (if fitted) is damaged or has been previously identified as leaking.

Cylinders identified as leaking shall be made safe prior to their reassessment.

5 Reassessment of cylinders

Cylinders that have been set aside (see 4.4) shall be examined by a competent person who shall determine if they are suitable for filling or if they shall be sent for reconditioning, where permitted by the appropriate annex, or disposal in accordance with EN 12816 (where applicable).

Cylinders that are intended to be filled by mass, and where the indication of tare weight is missing or illegible, shall be reassessed and have the indication of the tare mass applied in accordance with EN 14894.

Cylinders that are intended to be filled by volume, and where the indication of water capacity is missing or illegible, shall be reassessed and have the indication of the water capacity applied in accordance with EN 14894.

Leaking cylinders and cylinders with damaged or leaking valves shall be safely vented. Cylinders leaking through the body shall be disposed of in accordance with EN 12816 (where applicable). Leaking or damaged valves shall be repaired or replaced. In case of valve seals replacement, special care shall be taken to ensure that the replacement seals are resistant to gas (see EN 549, Pentane test).

Valves can be removed from and refitted safely to a pressurized LPG cylinder, provided the facility includes dedicated equipment. This equipment shall only be operated by a competent person working in accordance with a written procedure.

The filling plant shall have means to ensure that, when a valve is fitted, its thread is of the same type as the cylinder bung thread and its torque is compliant with both the cylinder and valve manufacturer's recommendations. The equipment used to fit valves shall be regularly checked, serviced and calibrated.

NOTE Rejection limits for physical, material and other defects on the cylinder shell are given in Annex A, Annex B, Annex C, Annex D and Annex G.

6 Filling conditions

Organization of the filling plant and filling procedure shall be in accordance with EN 13952.

7 Post filling checks

7.1 Check of filled amount

Each cylinder shall be checked to ensure that the maximum mass has not been exceeded, either by check weighing within the tolerances as determined by the relevant national competent authorities or by a determination of the ullage space remaining. Where accepted by the relevant national competent authorities, other systems of checking, such as sample weighing or statistical-data application, may be used when the filling mass is controlled automatically.

When cylinders are filled to a level, the fixed liquid level device shall be checked for operability.

7.2 Action necessary for over/under-filled cylinders

If the cylinder is over-filled, the excess LPG shall be removed as soon as reasonably practical and the cylinder re-checked.

If the cylinder is under-filled, the appropriate amount of LPG shall be added and the cylinder re-checked.

7.3 Final checks

Cylinders, valves and valve seals shall be checked for leakage. Leaks shall be dealt with in accordance with the procedures in Clause 5. The admissible leakage rate shall be either indicated in the national regulation or defined by the national competent authority, but in any case, not higher than 5 g/hour.

Equipment used to check for leakage shall be checked, serviced and calibrated regularly. Checks to ensure the correct functioning of the leak detectors on the filling line shall be made, as a minimum, at the beginning of every shift.

Cylinders shall be checked prior to dispatch or storage, for the correct fitting of valve caps or plugs, valve protection caps/guards and labelling, if required.

Annex A (normative)

Specific requirements for welded and brazed steel LPG cylinders

Rejection limits for physical, material and other defects on the cylinder shell are given in Table A.1, Table A.2 and Table A.3.

Table A.1 — Physical defects in the cylinder wall

Defect	Description	Rejection limit
Bulge	Visible swelling of the cylinder.	All
Dent	A depression in the cylinder that has neither penetrated nor removed metal, when its width at any point is greater than 2 % of the external cylinder diameter.	When the depth of the dent exceeds 25 % of its width at any point ^a .
Cut or gouge	A sharp impression where metal has been removed or redistributed.	Where the original calculated wall thickness is known: Depth of cut or gouge is such that the undamaged (remaining) wall is less than the minimum calculated wall thickness. Where the original calculated wall thickness is not known: All.
Dent containing cut or gouge	A depression in the cylinder within which there is a cut or gouge.	When the size of the dent, cut or gouge exceeds the dimensions for rejection as an individual defect.
Crack	A split or rift in the cylinder shell.	All
Lamination	Layering of the material within the cylinder wall appearing as a discontinuity, crack, lap or bulge at the surface.	All

^a Appearance (e.g. sharp dent) and location (e.g. on shoulder of the cylinder) also play a part in the evaluation of dent severity.